

Work Order ID 79204

79204

January-23-12 1:59:26 PM

Page 1

Item ID: D2662-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH In 206
 Start Date: 23/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2662	Rev E								

100
100 HAAS CNC VERTICAL MACHINING #1 0.00
 HAAS 1 OK/F.K 12/02/16 10
 HAAS CNC vertical machine #1
 Memo
 Program part number and batch number.
 Inspect part number and batch number are programmed

MACHINE AS PER FOLIO FB068 & DWG
 DWG REV: E
 FOLIO REV: E

110
110 CONVENTIONAL MILLING MACHINE 0.00
 Mill Conv OK/F.K 12/02/16 10
 Conventional Milling Machine
 Memo
 Machine Keyway and inspect per attached dimension sheet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC2- Inspect parts off machine FAI/FAIB	0.00				10	4		
120									
QC	Memo	0.00							
Quality Control									

130	QC8- Inspect parts - second check	0.00				10	4		
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

10X4M/12/02/21

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 10:30								
	OVENTEMPERATURE: 320°F								
	FINISH TIME: 11:05								
160	QC3- Inspect Part Finish	0.00							
160									
QC									
Quality Control	Memo	0.00							
170	Identify as per dwg & Stock Location: 435	0.00							
170									
Packaging									
Packaging	Memo	0.00							

10X PM 12/02/21

10 BL 12 0 0 1

12/2/21 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/2/21
MF
12-02-21

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NOTE: Date & initial all entries

Picklist Print

January-23-12 1:59:30 PM

Page 1

Work Order ID: 79204

79204

Parent Item: D2662-1

D2662-1

Parent Item Name: Saddle, LH In 206

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C00.06.22Removed P/O for powder coatEC

IPP Rev:D As per Rev D 07-03-19 JLM

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-001

Manufactured

No

100

Each

14.0000

1

10

D6101-001

**

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

14

69677

2

73774

11

76836

1

78598

10

FK 12/02/14

W/O:		WORK ORDER CHANGES					
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
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DART AEROSPACE LTD		Work Order:	79204
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662	Rev: E	DSK:	Rev:
			Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.124	.124	.124	.123	.123
G	0.210	0.230		.224	.223	.224	.224	.224
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.490	2.490	2.490	2.490	2.490
J	1.313	1.343		1.326	1.326	1.326	1.326	1.326
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.138	1.138	1.137	1.1375	1.1375
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145	.140	.140	.140	.140	.140	.140
P	0.240	0.260		.250	.250	.250	.250	.251
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.550	.550	.551	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.500	.500	.500	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.132	.118	.118	.119	.119
AE	0.235	0.240		.236	.236	.235	.236	.236
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.110	.109	.110	.110
AH	1.565	1.585		1.578	1.578	1.578	1.578	1.5745
AI								

W/O:		 WORK ORDER CHANGES					
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Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

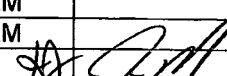
FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: EK. / 10/14 **Date:** 12/02/16

Audited by: RR **Date:** 12.2.16

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	

W/O:		WORK ORDER CHANGES					
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		Page 1 of 2	

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Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				6 X	7 X	8 X	9 X	10 X
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	0.100	0.140		.125	.124	.124	.124	.124
G	0.210	0.230		.225	.225	.225	.225	.224
H	0.615	0.685		.685	.685	.685	.685	.685
I	2.470	2.510		2.496	2.490	2.490	2.490	2.490
J	1.313	1.343		1.327	1.326	1.327	1.327	1.327
K	0.178	0.198		.188	.188	.188	.188	.188
L	0.470	0.530		.500	.500	.500	.500	.500
M	1.125	1.145		1.1385	1.137	1.1375	1.1375	1.1375
N	0.100	0.180		.135	.135	.135	.135	.135
O	0.100	0.145, 140		.140	.140	.140	.140	.140
P	0.240	0.260		.250	.251	.250	.250	.251
Q	0.677	0.697		.687	.687	.687	.687	.687
R	0.540	0.560		.550	.551	.550	.550	.550
S	0.912	0.932		.922	.922	.922	.922	.922
T	0.787	0.807		.797	.797	.797	.797	.797
U	5.990	6.010		6.000	6.000	6.000	6.000	6.000
V	4.995	5.005		5.000	5.000	5.000	5.000	5.000
W	0.490	0.510		.500	.497	.500	.500	.500
X	0.312	0.319		.314	.314	.314	.314	.314
Y	0.990	1.010		1.000	1.000	1.000	1.000	1.000
Z								
AA	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AD	0.100	0.140		.120	.120	.118	.118	.118
AE	0.235	0.240		.236	.236	.236	.236	.236
AF	0.510	0.515		.512	.512	.512	.512	.512
AG	0.100	0.120		.110	.110	.110	.110	.110
AH	1.565	1.585		1.5785	1.577	1.5775	1.5775	1.5775
AI								

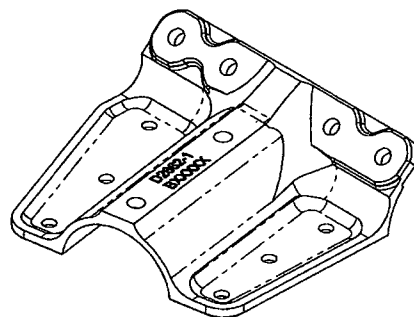
DART AEROSPACE LTD		Work Order:	79204
Description: 206 Saddle, Inboard, Left side		Part Number:	D2662-1
Inspection Dwg: D2662 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

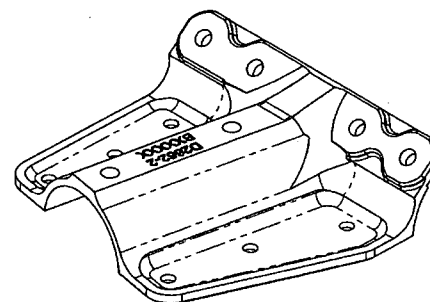
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: FK / <i>[Signature]</i>	Date: 12/02/16
Audited by: <i>[Signature]</i>	Date: 12-2-16
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue		
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	R-format; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>



D2662-1 SADDLE, INSIDE, LH



D2662-2 SADDLE, INSIDE, RH

RELEASED
2011-11-16

NO. 79204 M.L.J.
12/01/23

E	REDRAW & REFORMAT DWG; 0.667 WAS 0.547 (B8-2,B5-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORP DEO 9122/9102/9095/9137	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE SCALE NTS <small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. E	SHEET 1 OF 5
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
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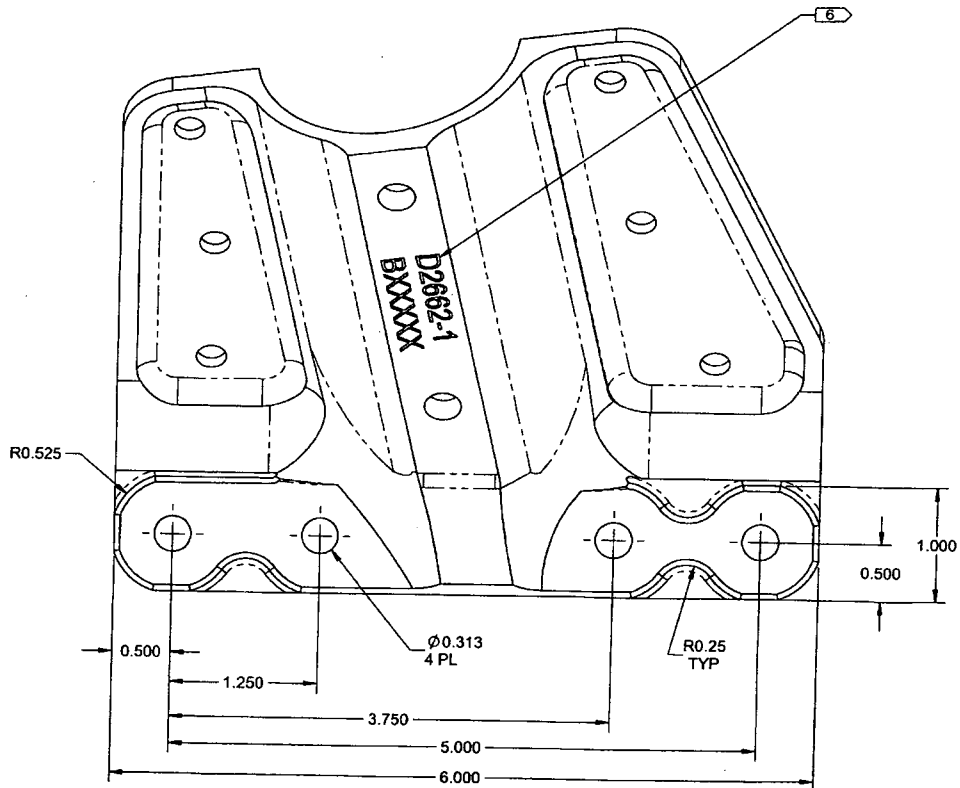
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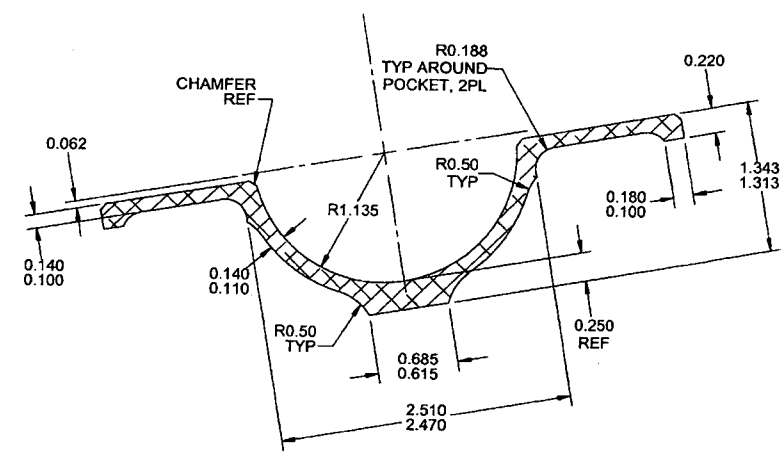
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VIEW B-B
SCALE 1.5X B4-2
VIEW ROTATED



VIEW A-A C1-2
SCALE 1.5X

RELEASED
2011-11-16

DESIGN	40	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2662 TITLE SADDLE, INSIDE COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV. E
DRAWN	40		SHEET 3 OF 6
CHECKED	AS		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE 11.10.31			

W/O:		WORK ORDER CHANGES					
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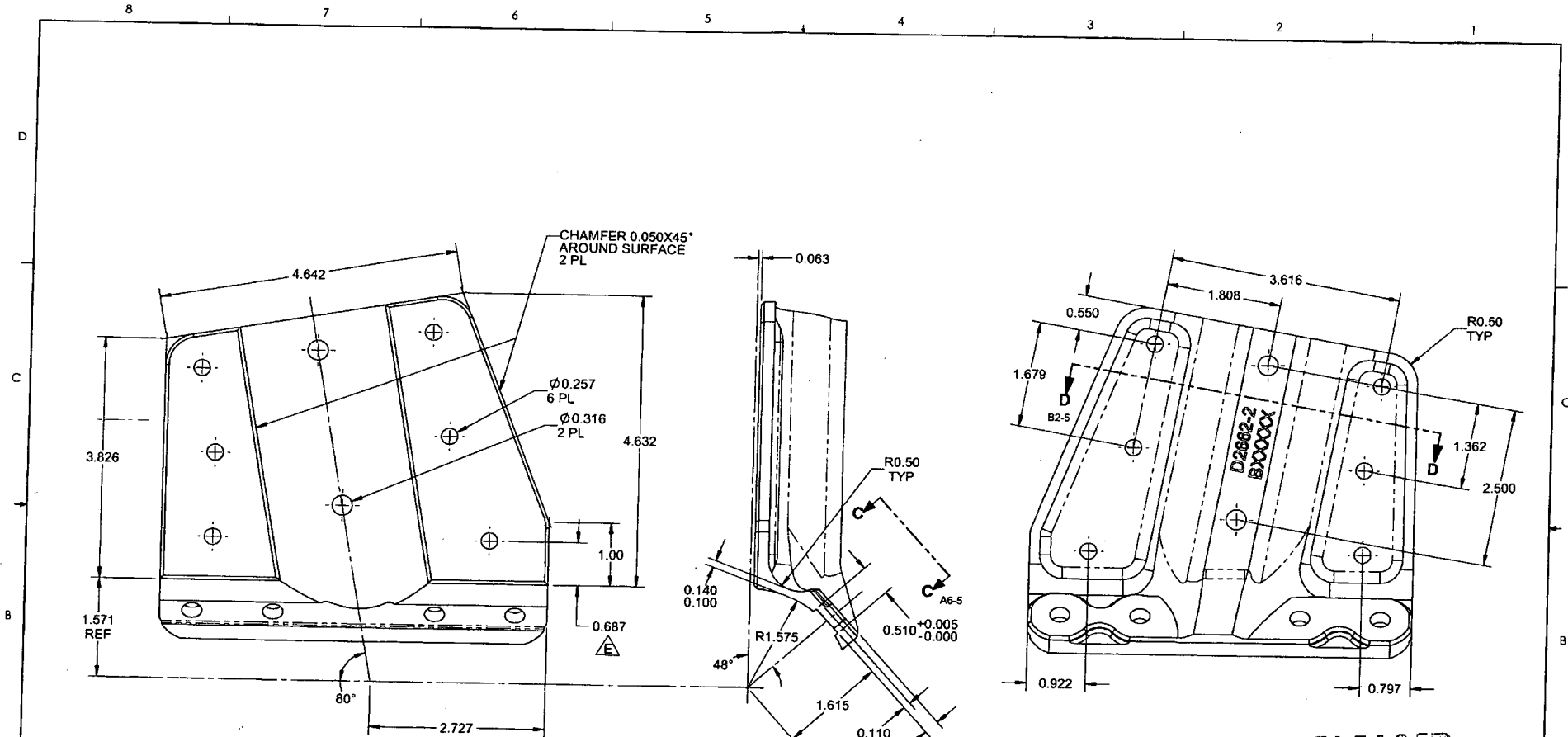
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7204



RELEASED
2011-11-16
MM

D2662-2 SADDLE, INSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-001 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 8.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
- 7) WEIGHT: 0.66 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2662	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, INSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

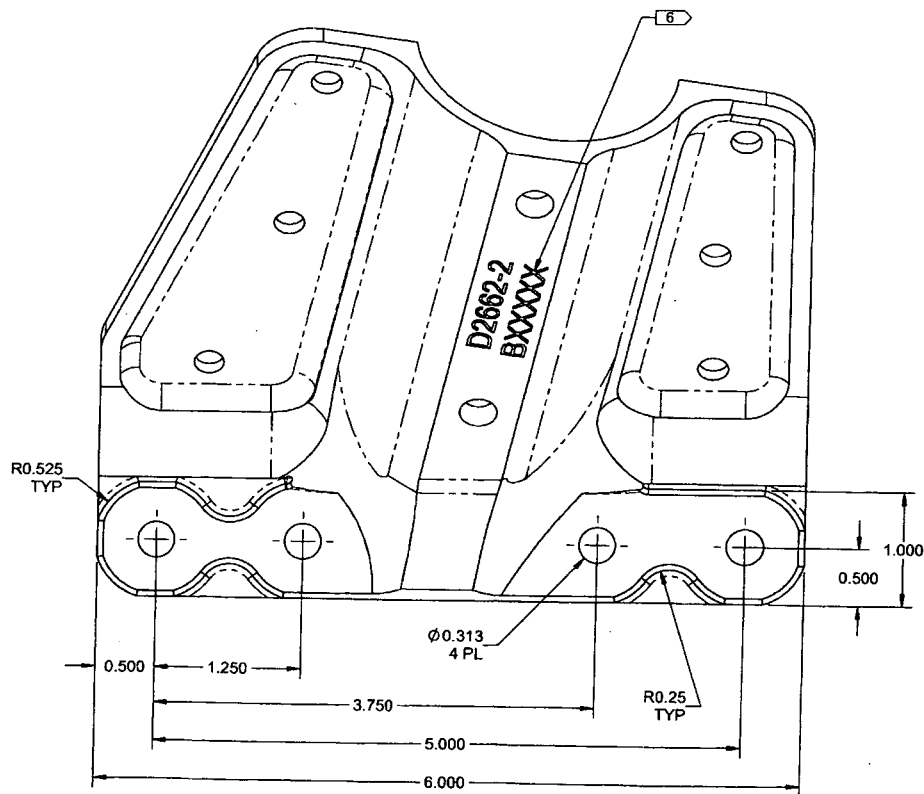
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

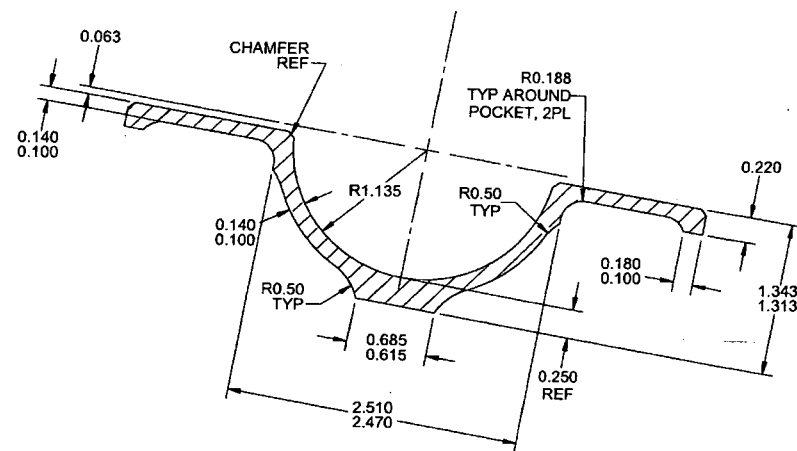
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79204



VIEW D-D
SCALE 1.5X B4-4
VIEW ROTATED



VIEW C-C
SCALE 1.5X C3-4

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2662	REV. E
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		SADDLE, INSIDE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries